

Date: Wednesday, 25/06/2008 10:02:04 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: UPPER RESTRAINT WELDMENT	
Job Number	: 40064				
Estimate Number	: 13398				
P.O. Number	:		^ Part Number	: PB674300131	
This Issue	: 25/06/2008	S.O. No. :	Drawing Number	: B6743001 P.41/ P.43	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: B1	
Previous Run	:		Material	:	
Written By	:		Due Date	: 04/07/2008	Qty: 5 Um: Each
Checked & Approved By	: <u>JUL 08. 08.25</u>		split		
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061-T6S090	6061-T6 .090 Sheet
Comment: Qty.: 0.4557 sf(s)/Unit Total : 2.2785 sf(s) 6061-T6 .090 Sheet batch: <u>108595</u> HB 8-7-15		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001 - 321 → 08.06.25 Dwg Rev: <u>B1</u> HB 8-7-15 Prog Rev: <u>B1</u> (6) ***grain direction along 25.00" *** 2-Deburr if necessary HB 8-7-15		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-15		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK S 08/07/15 (6)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg B67-43001 SB 08/07/16 (6)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 10:02:04 AM
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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08 07/16 (X6)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(6D)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.3

11/02/16 08/07/16

8.0 POWDER COATING

POWDER COATING



1102316

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 7:10 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 7:40 AM

11/02/16 08-07-17

(X6) (6)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Upper Pad Assembly

batch: 40064

11/02/16 08-08-26

11.0 NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

batch: 11/02/16

11/02/16 08-08-26

12.0 MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

Screw

batch: 11/02/16

11/02/16 08-08-26

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Date: Wednesday, 25/06/2008 10:02:04 AM
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Process Sheet

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Drawing Name: UPPER RESTRAINT WELDMENT

Job Number: 40064

Part Number: PB674300131

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg B67-43001

11/08/08 24 5

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

16.0 QC21

FINAL INSPECT

RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11/08/08 24

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

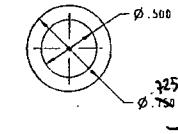
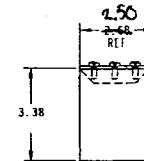
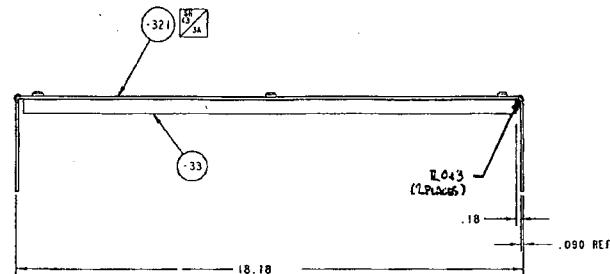
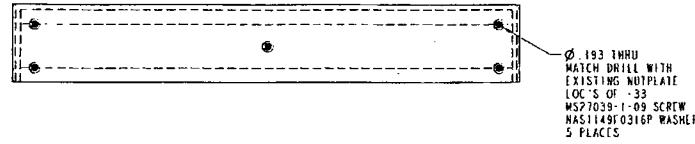
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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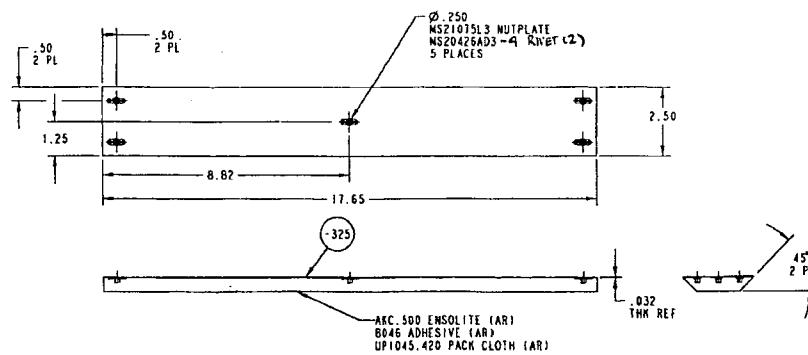
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 D C B A

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 ENGINEERING
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO *4001*

RELEASED
4-01-20

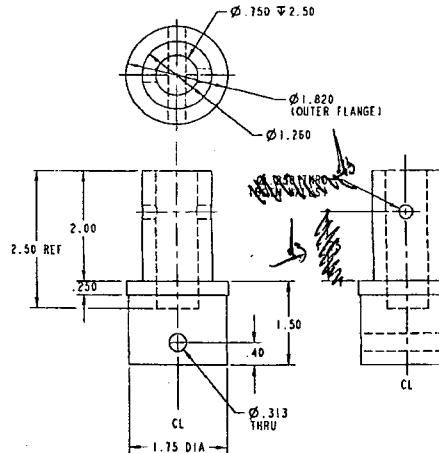


① -299 BUSHING $\frac{1}{4}$ $\frac{1}{4}$
 SCALE 2.000
 MAT: 304 CRES, COND A



① -33 UPPER PAD ASSY

SCALE .500
 MATL FOR .325: .032 THK 2024-T3 AL,
 QQ-A-25074



① -305 BEARING

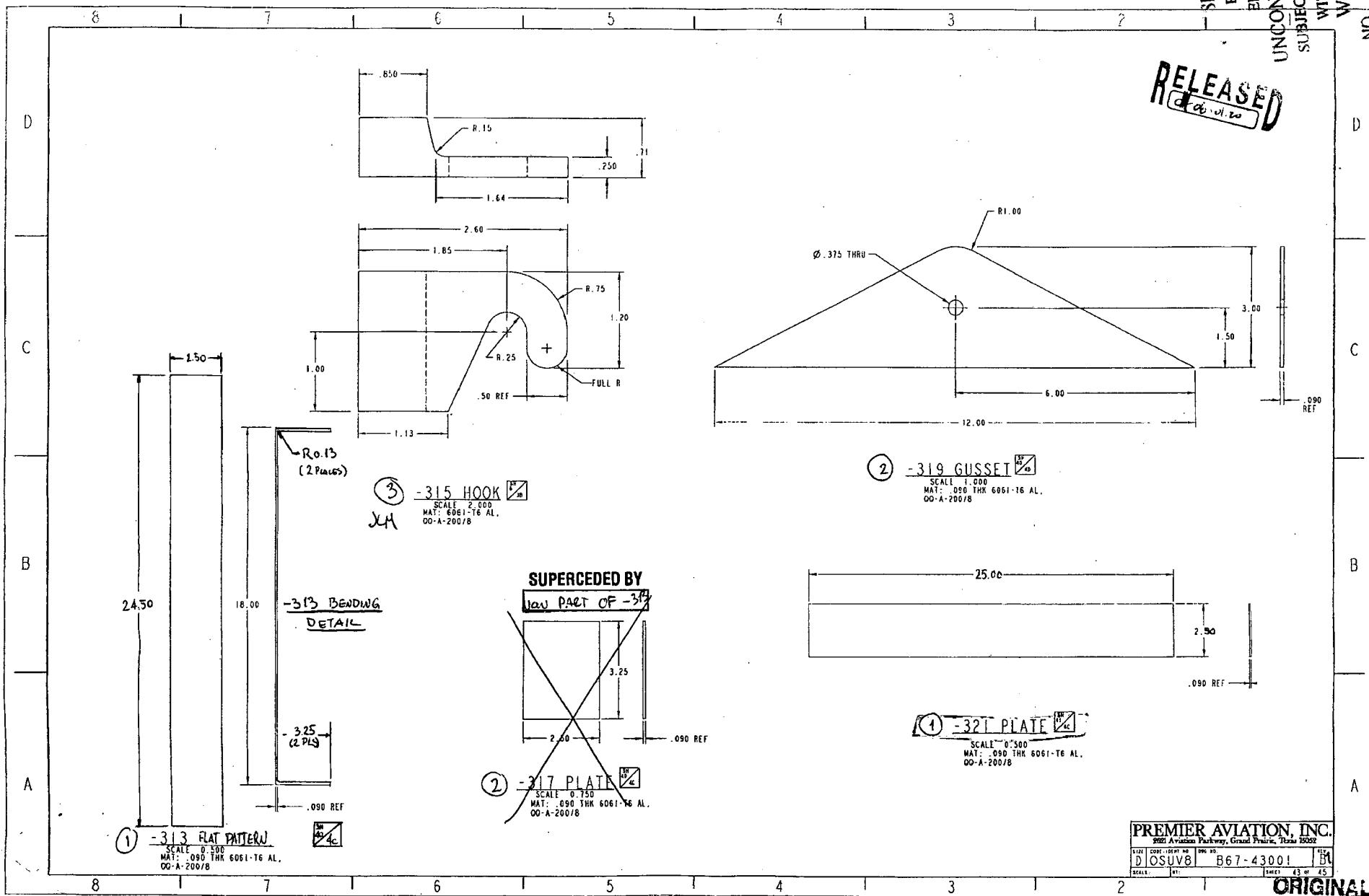
SCALE 1.000
 MAT: 2024-T3 AL,
 QQ-A-20073

PREMIER AVIATION, INC.
 200 Aviation Parkway, Grand Prairie, Texas 75050
 FAX: 972-237-1011, 900-871-0000
 D10SUVB B67-43001 B1
 STATE: 101 11 of 45

ORIGINAL

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PREMIER AVIATION, INC.
100 Aviator Parkway, Grand Prairie, Texas 75050
DOSUV6 B67-43001
Scale: 1:1
Date: 04-10-04
Page: 1 of 15

ORIGINAL

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DART AEROSPACE LTD	Work Order:	40064
Description: UPPER RESTRAINT WELDMENT	Part Number:	PB6743001-3
Inspection Dwg:	Rev: 6	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BB</u>	Audited by: <u>J</u>	Prototype Approval: <u>1</u>
Date: <u>8-7-15</u>	Date: <u>08/07/15</u>	Date: <u>9</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

